

Date:
User:Thursday, 3/30/2006 10:05:59 AM
Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 26450
 Estimate Number : 10311
 P.O. Number : N/A
 This Issue : 3/30/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : LANDING GEAR
 Previous Run : 24497
 Drawing Name : 206 EXTRUSION BENDING
 Part Number : D2620
 Drawing Number : D2620 REV B
 Project Number : N/A
 Drawing Revision : B
 Material : N/A
 Due Date : 4/20/2006 Qty: 10 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : 06.03.30
 Comment : Est. D 02.07.28 Change Dwg to rev.B; Updated Location RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D26001160 Extrusion Round 3" 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
 Extrusion Round 3" 206

Pick;

Qty	Part Number	Description	Batch
1	D2600-1	Extrusion Round 3" 206	B24508

DP06-4-12 (10)

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A
 and Folio Ft008

2- Cut Fwd end of tube as per Dwg D2620

DP06-4-12 (10)

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 06-04-12 (10)

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

DP06-4-12

(10)

5.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
 Inspection Level 21

DP 06/04/13 (10)

LG 06-04-13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: LD Date: 2/10/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

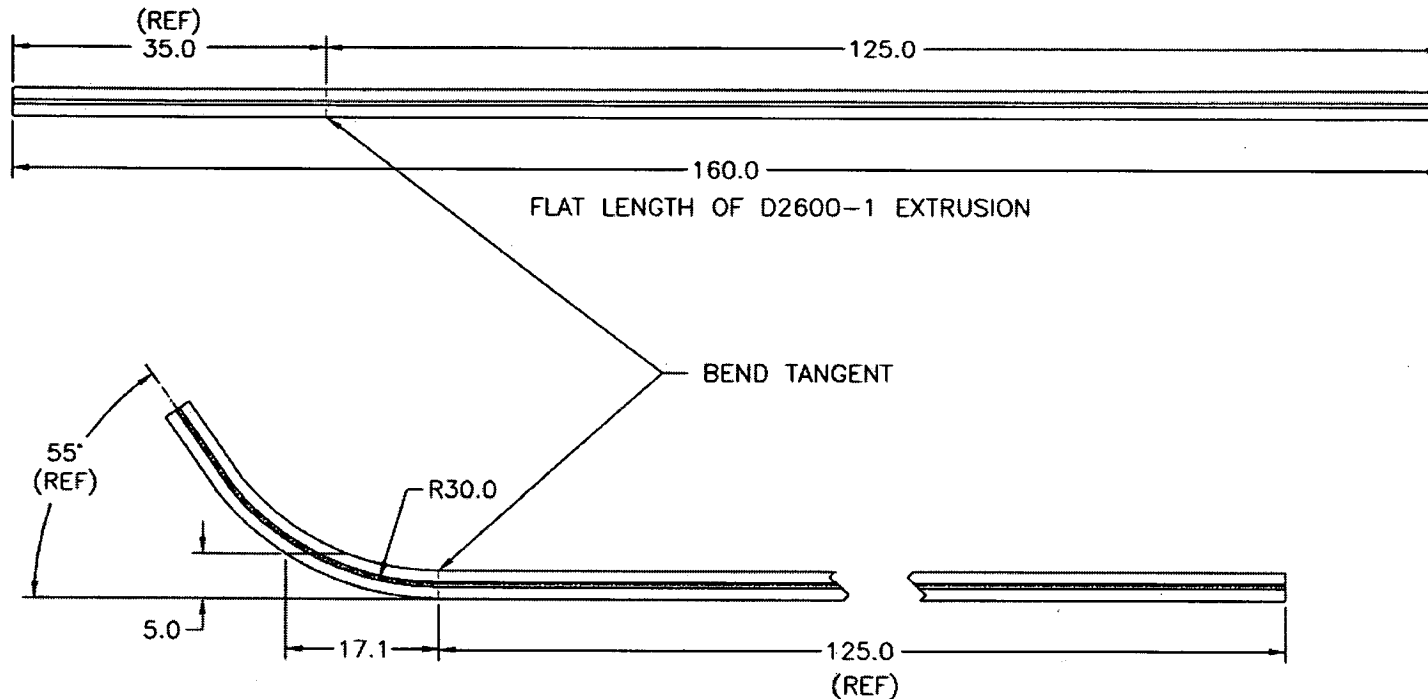
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING

206 SKIDTUBE BENDING



DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE. NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND. TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND. TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

DART



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	FARCHILD INTERNATIONAL AIRPORT, WA
DATE	TITLE	REV. B
99.09.10	206 SKIDTUBE BENDING CONTROL	SHEET 1 OF 1
A	97.11.07	NEW ISSUE
B	97.09.10	UPDATE FOR IN-HOUSE BENDING
		SCALE 1:20

RELEASED
44 04 15 DS

WORK ORDER
36450
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